



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5484-1
Job Sheet 195822



Part No: D5484-1

Job Qty: 23 pcs

Part Name: Aft Cap



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Created By: Kimberley Guerin

Due Date: 7/2/19

Description:

Type: Stock

Note: DWG REV A01 PP REV:A 17.05.26 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	23 pcs	7/2/19		0.00	0.00	Purchasing - 1		JUN 26 2019
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	23 pcs	7/2/19		0.00	0.00	Packaging 2 - 1 - B4B		JUN 26 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S194527



Part: D5484-1

Job No: 195822

Serial No/Batch: S194527

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/27/19

				Packaging 2 - 29 - B4B			
				Packaging 2 - 30 - B4B			
				Packaging 2 - 31 - B4B			
				Packaging 2 - 32 - B4B			
				Packaging 2 - 33 - B4B			
				Packaging 2 - 34 - B4B			
				Packaging 2 - 35 - B4B			
				Packaging 2 - 36 - B4B			
120	QC 6	23 pcs	7/2/19	0.00	0.00	QC 6 - 9	
						QC 6 - 68	
						QC 6 - 61	DAS
						QC 6 - 40	61 9-89
130	Packaging 3-1 - Stock - B4B	23 pcs	7/2/19	0.00	23.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	PC GA-124
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 - B4B	
140	QC 21 - SA	23 pcs	7/2/19	0.00	23.00	QC 21 - SA - 21	DAS
						QC 21 - SA - 70	21 9-89
						QC 21 - SA - 53	JUL 05 2019

Part Op **100** - Issue P/O: _____ Manufacture D5484-1C casting only as per dwg. Supplier: Metellurgie Syca Inc.
 Descriptions: Material release note required
110 - (Receive & Inspect for Damage & Mat'l Certs) Ensure Material Release Note is attached
120 - (QC6- All purchased or subcontracted products)
130 - (Identify as per dwg & Stock Location: _____)
140 - (QC21- Final Inspection - Work Order Release)

PO Details

Metallurgie SYCA (mes001-vc)



PO No: POHB043610

Line No: 2

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5484-1P	Aft Cap	23 pcs (1 ea)	100-Purchasing	SA4523

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D5484-1P	23	0	0

Part Specifications

Specifications could not be found.

Plex 6/27/19 12:51 PM dart.belanger.natasha



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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5484-1

Job Sheet 195822



Part No: D5484-1

Job Qty: 20 pcs

Part Name: Aft Cap



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Due Date: 7/2/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG REV A5 IPP REV:A 17.05.26 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Purchasing	20 pcs	7/2/19	7/2/19	0.00	0.00	Purchasing - 1	
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	20 pcs	7/2/19	7/2/19	0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
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							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	

Plex 5/30/19 3:50 PM Dart.Guerin.Kimberley

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
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					Packaging 2 - 36 - B4B	
120	QC 6	20 pcs	7/2/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
130	Packaging 3-1 - Stock - B4B	20 pcs	7/2/19	0.00 20.00	Packaging 3 - 1 - B4B	
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					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - SA	20 pcs	7/2/19	0.00 20.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - Issue P/O: _____ Manufacture D5484 as per dwg. Supplier: Metellurgie Syca Inc. Material release
 Descriptions: note required

110 - (Receive & Inspect for Damage & Mat'l Certs) Ensure Material Release Note is attached

120 - (QC6- All purchased or subcontracted products)

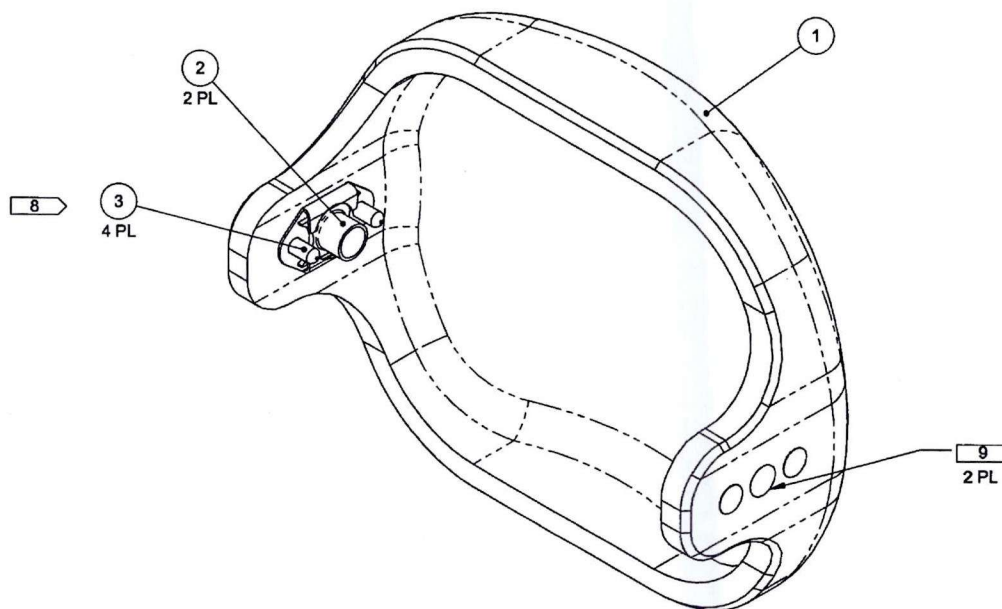
130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D5484-1P	Aft Cap	20 pcs (1 ea)	100-Purchasing	
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D5484-1P	20	0	0
Part Specifications				
Specifications could not be found.				

Plex 5/30/19 3:50 PM Dart.Guerin.Kimberley

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5484-041	AFT CAP ASSY
1	1	D5484-1	AFT CAP
2	2	MS21075L3N	NUT PLATE, SELF-LOCKING, FLOATING
3	4	CCR264SS-3-04	RIVET, BLIND, CSK



D5484-041 AFT CAP ASSY

NOTES:

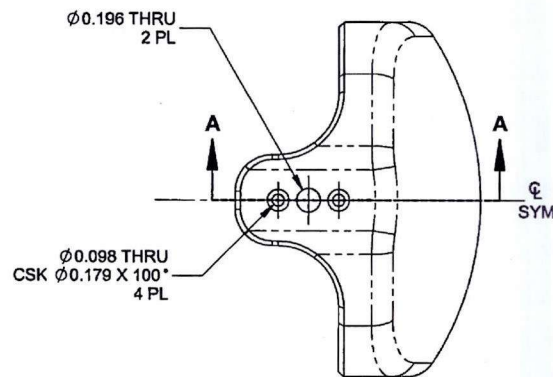
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE PER QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.29 LBS
- 8) IT IS ACCEPTABLE TO USE LONGER OR SHORTER CCR264SS-3 RIVETS TO INSTALL THE MS21075L3N NUTPLATE REF: AC43:13-1B CHAPTER 4
- 9) MASK PRIOR TO FINISHING

RELEASED
2017-10-31
EON 17-728

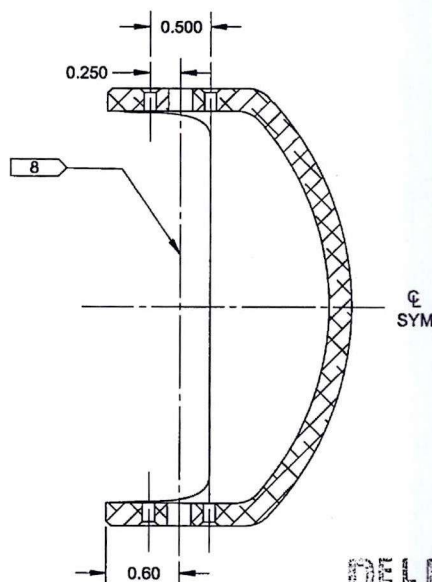
APPROVED

A	NEW ISSUE	NO	17.02.14
REV.	DESCRIPTION	BY	DATE
DESIGN	NO	DART AEROSPACE USA, INC. EUGENE, OR DRAWING NO. D5484 REV. A SHEET 1 OF 3 TITLE AFT CAP SCALE NTS	
DRAWN	NO		
CHECKED	AJS		
MFG. APPR.	JFS		
APPROVED	WM		
DE APPR.	DS		
DATE	17.02.14		

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D5484-1
(DRILLING DETAIL)



SECTION A-A

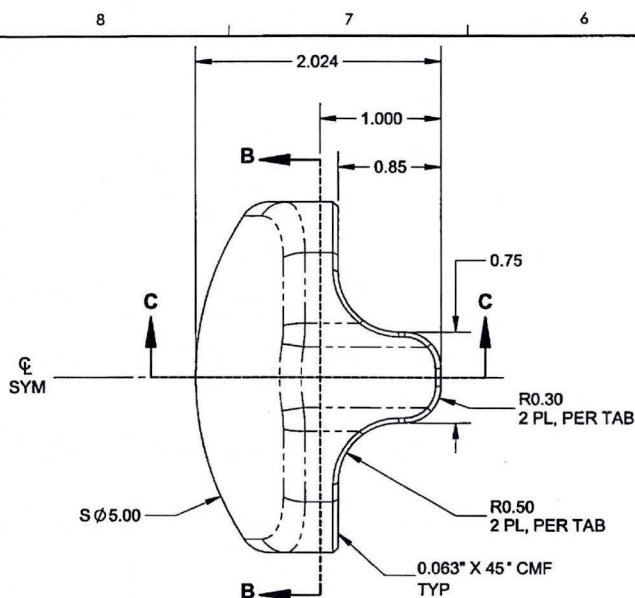
NOTES:

- 1) MATERIAL: MAKE FROM D5484-1C
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) Ø0.196 HOLES TO BE ALIGNED WITHIN ±0.005 OF EACH OTHER AS SHOWN (2 PL)

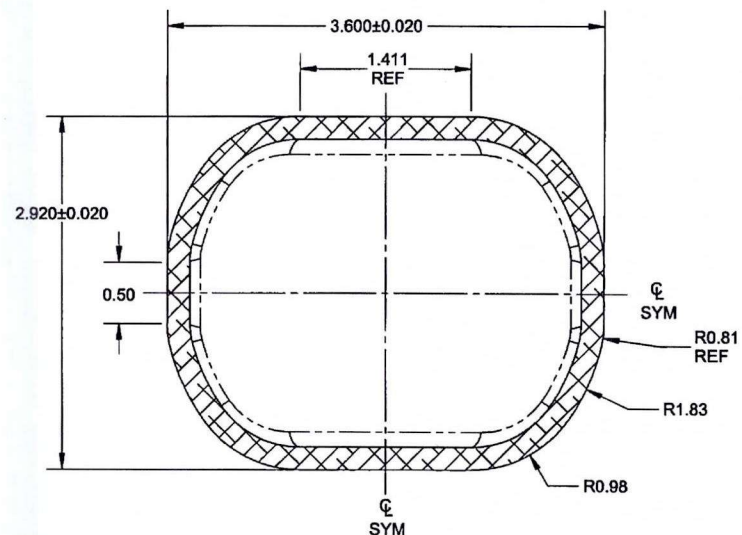
RELEASED
2017-10-31

APPROVED

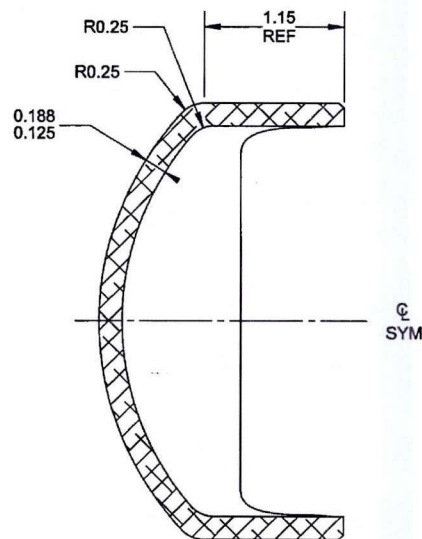
DESIGN	NO	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	NO		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	JFS	D5484	SHEET 2 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	AFT CAP	NTS
DATE	17.02.14	COPYRIGHT © 2017 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D5484-1C AFT CAP



SECTION B-B



SECTION C-C

NOTES:

- 1) MATERIAL: CAST FROM A356.0 PER AMS 4218 AND HEAT TREAT TO T6 CONDITION
PROPERTIES TO BE VERIFIED BY SUB-SIZED SEPARATELY CAST TEST BARS
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.286 LBS
- 8) COSMETIC WELD REPAIR PER AMS 2694 PRIOR TO HEAT TREAT AND INSPECTION
- 9) INSPECTION: EACH PART MUST PASS VISUAL CL. 4 PER AMS 2175
- 10) ALL NON DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.030 PER
CAD FILE D5484-1-REV_A.STP

RELEASED
2017-10-31

APPROVED
WJE

DESIGN	NO	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	NO		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	JFS	D5484	SHEET 3 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	AFT CAP	NTS
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB043610



Supplier: MES001-VC
Metallurgie SYCA
500 Principale,
St.Dominique
QC
JOH 1LO Canada
Phone: 450-261-0853
Fax: 450-261-0894

PO No: POHB043610
PO Date: 6/3/19
Due Date: 6/28/19
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Fedex P1 Overnight
Pymt Terms: Wire
Freight Terms:
Special Comments:

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		D2855P			Cap As per Dwg D2855 Rev. C wo 195924	Firmed	-	6/27/19	57 pcs	0 pcs	57 pcs	\$18.875/pcs	\$1,075.88
Line Item Note note price include certification fees wo 195924 x 57 pcs and wo 195800 x 57 pcs													
								6/28/19	57 pcs	0 pcs	57 pcs	\$18.875/pcs	\$1,075.88
Sub Total:									114	0	114		\$2,151.75
2	195822	D5484-1P			Aft Cap AS PER DWG D5484 REV. A please note casting only required no holes	Firmed	-	7/2/19	23 Ea	0 Ea	23 Ea	\$34.125/Ea	\$784.88
Line Item Note note price include certification fees													
Grand Total:												\$2,936.63	



Dart Aerospace Ltd.
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Hawkesbury, ON
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Canada

Tel (613) 632-5200

PURCHASE ORDER POHB043610



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 6/27/19 12:49 PM dart.belanger.natasha

Métallurgie Syca inc

PACKING SLIP

POHB043610

500 RUE PRINCIPALE, ST-DOMINIQUE, QUEBEC J0H 1L0

Phone: (450) 261-0853 Fax: (450) 261-0894

Sold to			Ship to			CUST. P.O.	
DART AEROSPACE LTD						POHB043610 ✓	
1270, ABERDEEN STREET HAWKSBURY, ON K6A 1K7						Due date	
Phone: (613) 632-9577						Ship via	
						TRANSP. CLIENT	
Buyer	Salesman	N° TPS	N° TVQ	# account	Transport paid by	Verify per	Page
	ROXANNE	873216006	1204830718				1
# Product	Description	Qty ordered	Qty shipped	Reference no			
D-2855 ✓	CAP D-2855	50	50 ✓	3242			
D-2855 ✓	CAP D-2855	50	64 ✓	3243			
D5484-IP ✓	AFT-CAP	20	23 ✓	3244			
CERTIFICAT	Certificat de conformité	1	1				

DAS
61
9-89

RECEIVED

JUN 27 2019

DART AEROSPACE LTD.**Comments**

Signature _____

METALLURGIE SYCA

Certificate of compliance

This is to certify that the below named items were inspected and tested to approved specification only. Objective evidence is on file to support the verifications and tests and can be made available at our facilities on request unless otherwise noted.

Customer name: **DART AEROSPACE**

Delivery address: **1270, Aberdeen Street**

Hawksury, ON

Purchase Order # : POHB043610 ✓

Quantity supplied

Part number

Part name

DAS
61
9-89

114 ✓

D -2855 ✓

CAP D-2855

23 ✓

D5484-1P ✓

AFT-CAP

Signed by: _____

Date: _____

27/06/2019

Métallurgie Syca

500, Principale, Saint-Dominique, QC J0H 1L0

Tél. (450) 261-0853 Téléc. (450) 261-0894

roxanneg@syca.ca